

Work Order ID 76640-2

November 18, 2011 10:23:17 AM

76640

Page 1

Item ID: D2230-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 11/18/11 Start Qty: 160.00

160

Cust Item ID:

Required Date: 11/25/11 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: 11/11/18

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: *68331*

extrusion cut @ meter

CL 11/11/18

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1 *perch*

HAAS CNC vertical machine #1

Memo

0.00

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

P/O. 15479

CL 11/11/18 200

*issue P/O. to meter
Machine as per draw D 2230 REV.G*

/

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Work Order ID 76640

November 18, 2011 10:23:17 AM

76640

Page 3

Item ID: D2230-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 11/18/11 Start Qty: 160.00

160

Cust Item ID:

Required Date: 11/25/11 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

199 ~~11-12-7~~
Mk

160

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:20

OVEN TEMPERATURE: 320 OF

FINISH TIME: 7:50

199X M-11/12/08

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

199 11-12-8

M 119480

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 76640

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Page 4

Item ID: D2230-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 11/18/11 Start Qty: 160.00

160

Cust Item ID:

Required Date: 11/25/11 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: 480

0.00

180

Packaging

Memo

0.00

Packaging

Rec'd 11/13/13 255

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/12/13

MF 11-12-13

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

November 18, 2011 10:23:17 AM

Page 1

Work Order ID: 76640

Parent Item: D2230-1

Parent Item Name: Lug

Start Date: 11/18/11

Required Date: 11/25/11

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coat EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------------|---------------|----------------|--------|
| D2230-1P ✓ LUG | | Purchased | No | | | | Each | 0.0000 | | 160 200 | | 11/14/11 | |
| D2423 Lug Extrusion | | Manufactured | No | | | 110 | f | 455.0800 | 0.0683 | 11.503158 | | 11/11/11 | |

Location

Loc Qty

Loc Code

MAT006

455.08

43722

161.5

45800

1

68331

292.58

13.66

13.669

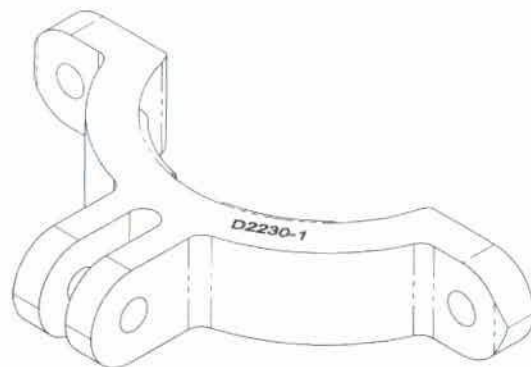
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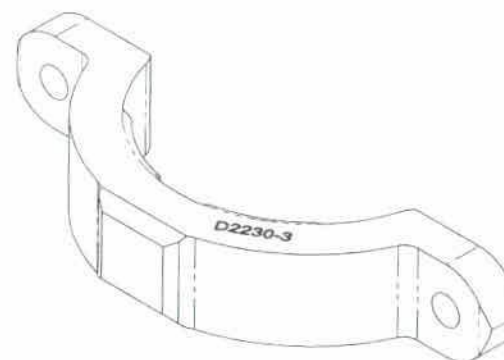
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

cf 111118
W/O: 76640

RELEASED
AJS



NOTES

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1, 0.16 lbs
-3, 0.14 lbs

| | | | |
|------------|---|---|--------------|
| G | REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION | AJS | 09.01.16 |
| F | REDESIGN, R1.200 WAS 1.100 | CP | 99.12.13 |
| E | RE-DESIGN | BW | 95.01.04 |
| D | RE-DESIGN | BW | 95.01.04 |
| C | RE-DESIGN | BW | 94.03.30 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2230 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MOUNTING LUG | NTS |
| DATE | 09.01.16 | <small> COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small> | |

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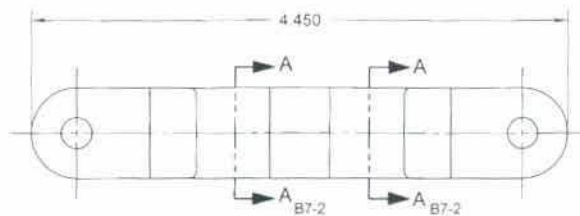
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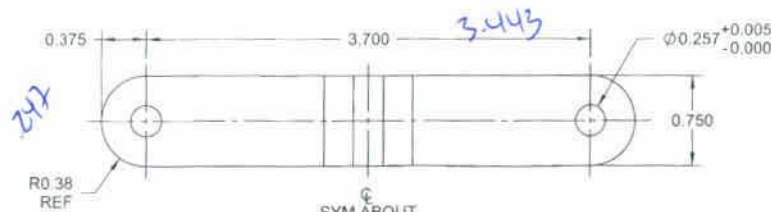
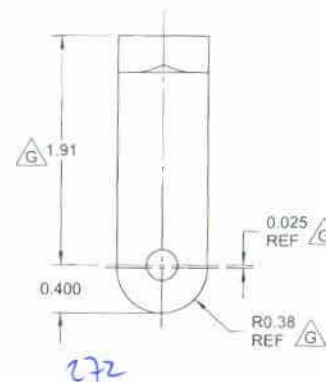
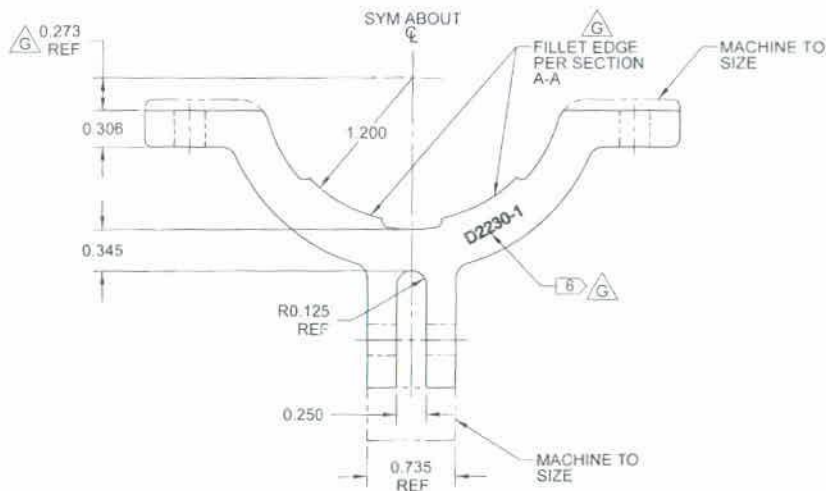
NOTE: Date & initial all entries

to
180



R0.05 MIN - R0.10 MAX
2 PL

SECTION A-A D4.2
SCALE 2X



D2230-1 MOUNTING LUG

RELEASED
09/06/25

| | | | |
|------------|----------|---|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO D2230 | REV. G |
| MFG. APPR. | | TITLE | SHEET 2 OF 3 |
| APPROVED | | MOUNTING LUG | SCALE |
| DE APPR. | | | NTS |
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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

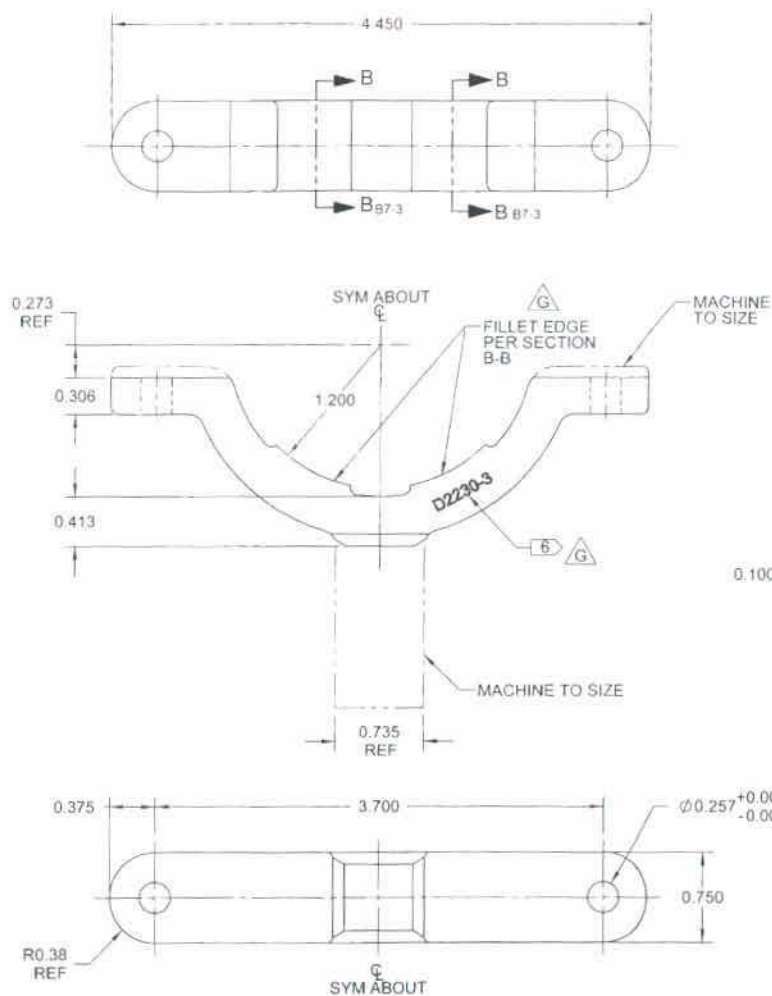
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NOTE: Date & initial all entries

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25M

| | | | |
|-----------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO | REV. G |
| MFG. APPR | | D2230 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR | | MOUNTING LUG | NTS |
| DATE | 09.01.16 | COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS HEREBY RELEASED FOR THE PUBLIC TO USE IN WHATEVER MANNER THEY SEE FIT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15479

Purchase Order Date 11/18/11

PO Print Date 11/18/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD.

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CH/11/15

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|-----------|--|------------------------|---|-----------------------------|-------------|------------|-------------------|
| D2230-1P | | LUG | 11/21/11 Yes | 200.00 Each | Dart Truck | \$18.9500 | \$3,790.00 |
| | | Special Inst: | MACHINE AS PER DWG D2230 REV. G B76640 | | | | |
| D2230-3P | | LUG | 11/18/11 Yes | 200.00 Each | Dart Truck | \$13.6000 | \$2,720.00 |
| | | Special Inst: | MACHINE AS PER DWG D2230 REV. G B76642 | | | | |
| PO Total: | | | | | | | \$6,510.00 |



Change Nbr: 1

Change Date: 11/18/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel. (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18274
Date: Nov 21, 2011
Page: 1

| | |
|--|---|
| Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 | Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 |
| Order No.: PO15479 | Sold By: Dewar, Eric |
| Shipped By: your truck | Ship Date: Nov 22, 2011 |

| Description | Unit | Ordered quantity | Shipped quantity | Backorder quantity |
|--|------|---------------------------|------------------|--------------------|
| D2230-1 Mounting Lug, machine as per drawing D2230 REV.G B76640 | Each | 200 | 200 | |
| D2230-3 Mounting Lug, machine as per drawing DWG D2230 REV.G B76642 | Each | 200 | | 200 |
| The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted. | | | | |
| Received by _____ | | Thank you for your order! | | |



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|------------------|--------------------|
| 200 | D2230-1 | Mounting Lug | 15479 |

MATERIAL: supplied by DART D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

A handwritten signature in black ink, appearing to read "Jan Norris", is written over the printed name.

Vankleek Hill, November 21 2011